

Work Order ID 71153

Thursday, June 23, 2011 12:37:33 PM



Page 1

Item ID: D4039-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Bracket

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-06-23 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4039	B
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100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4039-1_BLANK

60611.X 18

B 11-7

(4)

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA880 AND DWG

FOLIO REV: BAA

DWG REV: B

DEBURR

FK 12/06/15

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

FK 12/06/15

4

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

cmk 12/06/16

4

15

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

AS

12-6-17 (4)

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Start Time = 8:00

0.00

Temp = 3200 F

Finish Time = 8:30

4X

M-L
12/06/18

Powdercoat

Memo

Powder Coating

M121134

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

H.P.

12-6-18

Quality Control

170

Identify as per dwg & Stock Location

0.00

Packaging

Memo

0.00

(4)

12/6/18

Packaging

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Customer:

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Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/6/19 JH

112-06-19

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Picklist Print

Thursday, June 23, 2011 12:37:29 PM

Page 1

Work Order ID: 71153

Parent Item: D4039-1

Parent Item Name: Fwd Bracket



Start Date: 6/23/2011

Required Date: 7/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC
B:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased	No			100	f	12.2000	3	12.63158			



6061-T6 Bar 1.00 x 15.00



B11-7-

Location	Loc Qty	Loc Code
MAT005	12.2	
115173	12	
117372	0.2	
118184		

118184

4

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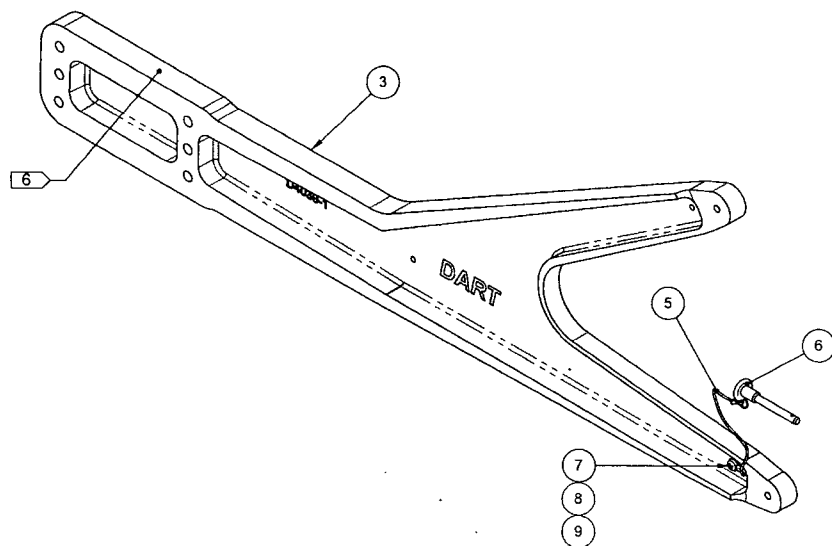
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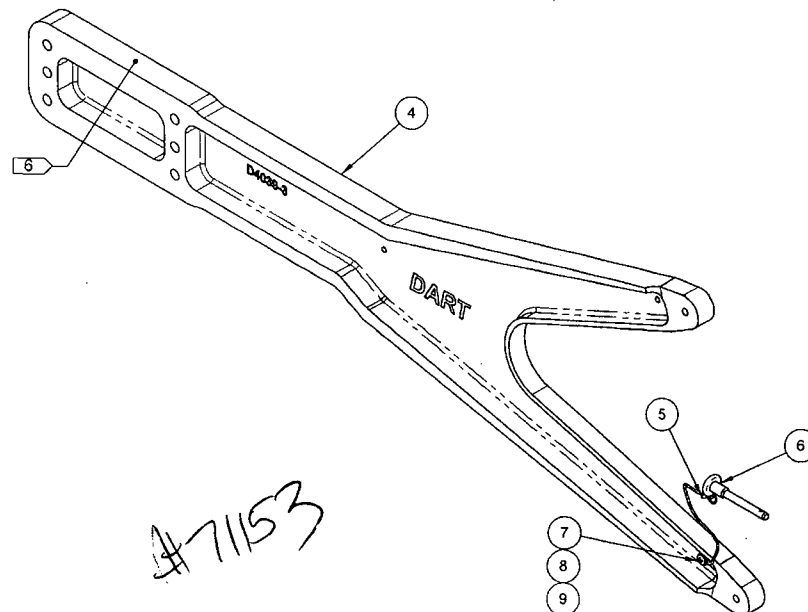
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ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4039-041	FWD BRACKET ASSEMBLY
2		X	D4039-043	AFT BRACKET ASSEMBLY
3	1		D4039-1	FWD BRACKET
4		1	D4039-3	AFT BRACKET
5	1	1	D2690-6	LANYARD
6	1	1	BLRS-010	PIP PIN
7	1	1	MS27039-1-11	SCREW
8	1	1	MS21042L3	NUT
9	3	3	NAS1149D0363J	WASHER



D4039-041 FWD BRACKET ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: N/A



D4039-043 AFT BRACKET ASSEMBLY

RELEASED
2010-09-27

B	REVISE HOLE SIZE ON D4039-3 FROM 0.191 TO 0.203, ZN	HS	10.04.28
A	NEW ISSUE	HS	09.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4039** REV. B
SHEET 1 OF 3
TITLE **BRACKET** SCALE NTS

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